

Date: Thursday, 05/02/2009 9:19:51 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RIB ASSY (BASKET END)
 Job Number : 45505
 Estimate Number : 13666
 P.O. Number : Part Number : D3825041
 This Issue : 05/02/2009 S.O. No. : Drawing Number : D3825 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 44755 Material :
 Due Date : 12/02/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : SAO 09-02-05
 Comment : Est Rev:A 08-12-01 new issue DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Spacer Bushing
 Batch: B39560

PD 09-02-17

2.0 D37591 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Bushing B39560 45794

PD 09-02-17

3.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 2.2313 f(s)/Unit Total: 8.9250 f(s)
 304 SQ Tube .75x.75x.065W
 batch: M110561

SAO 09-02-12 Y

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1- cut D3825-1 rib as per dwg D3825
 2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825
 3- c'sink hole as per dwg
 4- remove identification markings
 5- deburr

SAO 09-02-12 Y

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 9:19:51 AM
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Process Sheet

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Drawing Name: RIB ASSY (BASKET END)

Job Number: 45505

Part Number: D3825041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/02/12 (24)

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R ER316 S.S. Rod Batch: M107051

2- grind bushing weld flush where indicated on dwg D3825

3- deburr if necessary

PD 09-02-17 (4)

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-02-17

(4)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-17 (4)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket c.

PD 09-02-17

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



MF 09-02-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

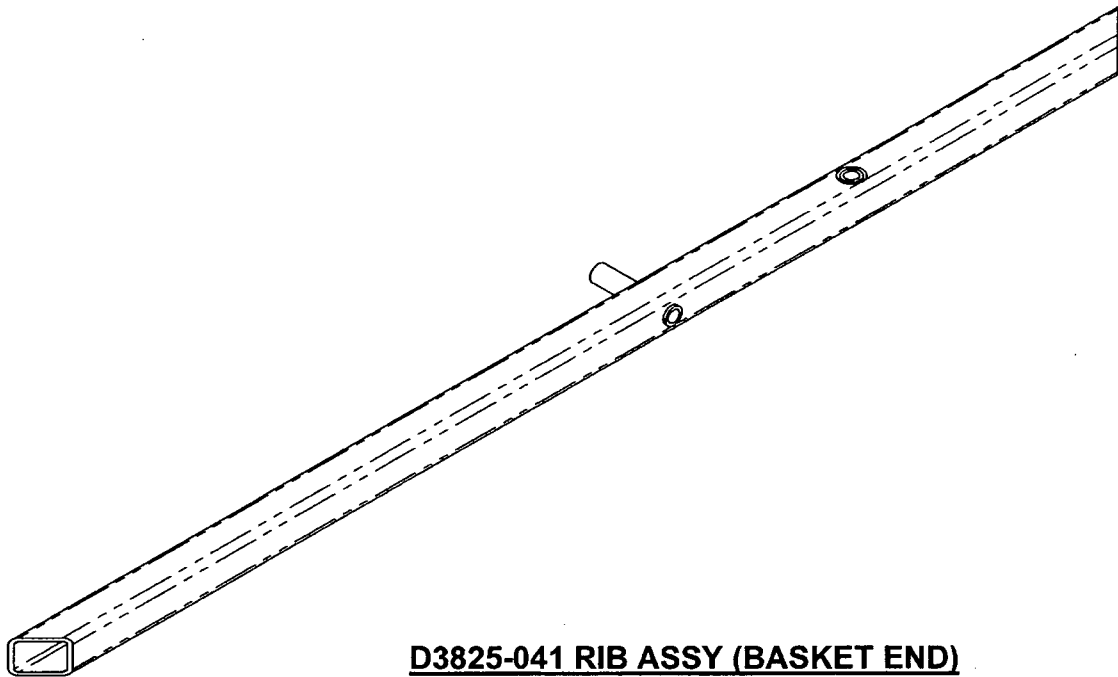
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB

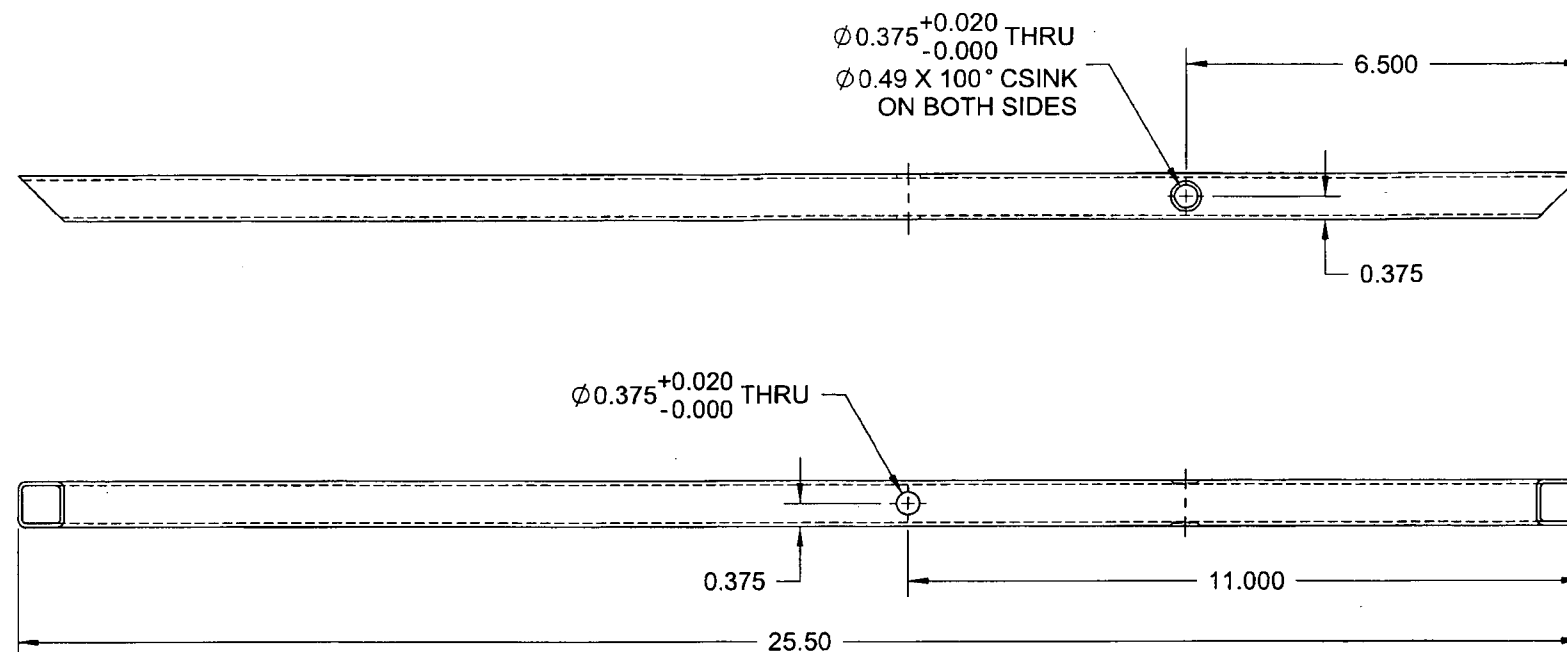
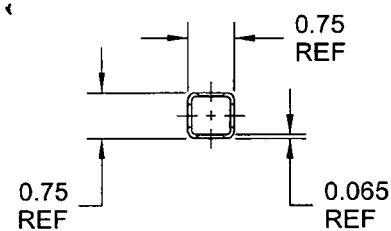


D3825-041 RIB ASSY (BASKET END)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) WELDING: PER DART QSI 004

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45505

A	NEW ISSUE	MB	08.09.23
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3825-1 RIB

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45505

RELEASED
08/11/13 MB

- NOTES:**
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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